

Date: Wednesday, 5/23/2007 3:26:30 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HARNESS ASSEMBLY
Job Number	: 32484		
Estimate Number	: 12854		
P.O. Number	: <i>N/A</i>	Part Number	: D412702101B
This Issue	: 5/23/2007 S.O. No. : <i>N/A</i>	Drawing Number	: ICA D412-702 P.79
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision	: <i>03</i>
Previous Run	: 32332	Material	: <i>N/A</i>
Written By	:	Due Date	: 6/1/2007
Checked & Approved By	: <i>07.05.24</i>	Qty:	10 Um: Each
Comment	: est rev A 07.05.10 new issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL
 type labels per PPP D412-702-101B CHG001

N/A

2.0	D35737	ADAPTER
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Comment: Qty.: 1.0000 Each(s)/Unit Total : ~~10.0000~~ Each(s)
 ADAPTER
 batch: *B 31864-1* *x6*

✓

3.0	D3579046	SHOULDER HARNESS RH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : ~~10.0000~~ Each(s)
 SHOULDER HARNESS RH
 batch: *B 32115* *x6*

✓

4.0	K62	CLIP
-----	-----	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : ~~10.0000~~ Each(s)
 CLIP
 batch: *M104426* *x6*

✓

5.0	MS24693S272	Screw
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Comment: Qty.: 4.0000 Each(s)/Unit Total : ~~40.0000~~ Each(s)
 Screw
 batch: *M104438* *x24*

✓

M107/05/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 5/23/2007 3:26:30 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HARNESS ASSEMBLY

Job Number: 32484

Part Number: D412702101B

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

AN960JD10LL

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: ~~40.0000~~ Each(s)

Washer

batch: M19085

X 24



7.0

MS21042L3

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: ~~40.0000~~ Each(s)

Nut

batch: M103691

X 24



M107/05/29

8.0

D35693

DECAL



Comment: Qty.: 1.0000 Each(s)/Unit Total: ~~10.0000~~ Each(s)

DECAL

batch: B32540

X 6

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg ICA D412-702 p.79

4 Marine adhesive 520 M104524

See Attached E-mail

M107/06/04

X 6

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07.06.04

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-702-101B CHG001

Location: _____

PPP Rev: _____

07/06/04 (6)

Job Completion



QC21 Final inspection w/o release

U 0706-04
0706/05 (6)

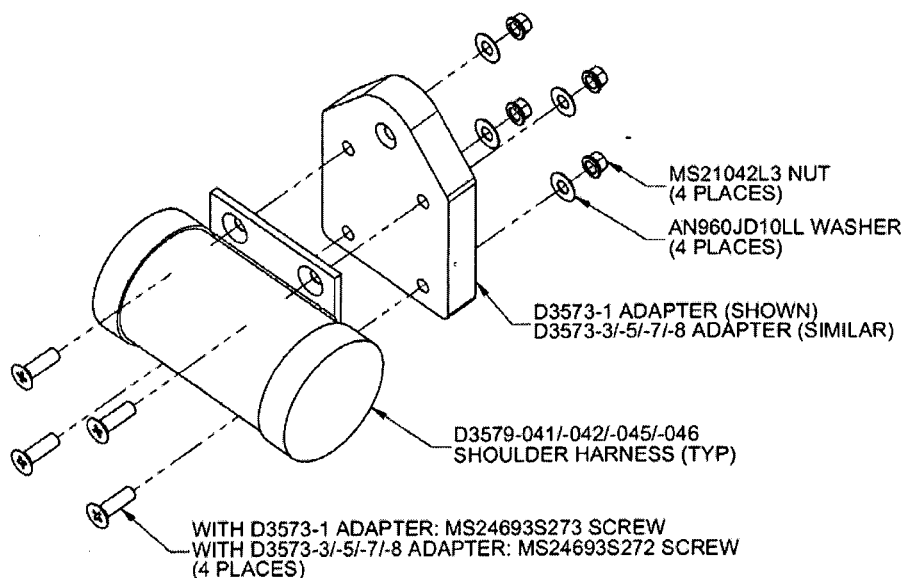
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

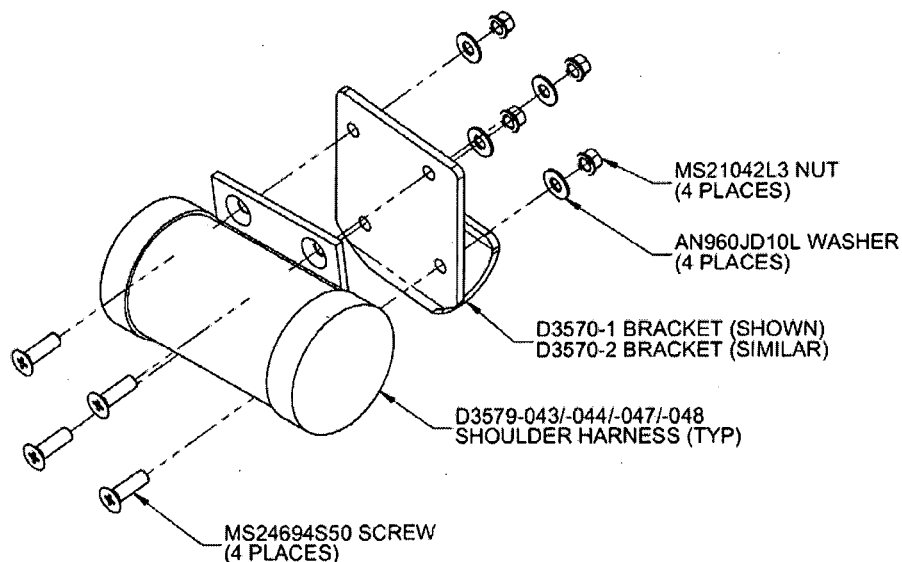
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**DETAIL 'K' D412-702-101A/-103A/-105A/-107A/-109A/-115A/-117A AND
D412-702-101B/-103B/-105B/-107B/-109B/-115B/-117B HARNESS ASSEMBLIES**
(BELTS, K6.2 CLIP AND D3569-1/-2/-3 DECAL NOT SHOWN)



DETAIL 'L' D412-702-111A/-111B/-113A/-113B HARNESS ASSEMBLIES
(BELTS AND D3569-1/-2/-3 DECALS NOT SHOWN)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32484

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COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Dale Trepanier

From: Leanne Elsliger [lelsliger@dartaero.com]
Sent: Tuesday, June 05, 2007 8:44 AM
To: 'Jason Murdoch'; dtrepanier@dartaero.com
Subject: Adhesive for D3569 Decals

Attachments: ATT00010.txt; .pdf



ATT00010.txt (113 B)
.pdf (346 KB)

Jason, Dale,
Here is the info from Schroth saying that we can use the 3M Marine Adhesive 5200 on their buckles.

Leanne

-----Original Message-----

From: pow@mmm.com [mailto:pow@mmm.com]
Sent: May 22, 2007 9:04 AM
To: lelsliger@dartaero.com
Subject: Message from [marianne.kump@armorholdings.com] containing forwarded 3M document (Adhesive Sealant Brochure)

This information was forwarded to you by a visitor of the 3M website and it was sent from an unmonitored e-mail address. To reply to the sender, please do so to the address the sender included in the subject bar. This e-mail feature is offered for the benefit of 3M customers to share information about 3M products and services, and any other use of this e-mail feature is prohibited. Any message included with this e-mail was drafted by the sender and 3M assumes no responsibility for the content of any message. For more documents like the one attached, visit www.3m.com.

3M Product Information: 3M(TM) Marine Adhesive/Sealant 5200 3M Product Data: Adhesive Sealant Brochure

----- The sender has included this message. ----- Leanne,

Here is the spec sheet for the adhesive we recommend. This comes in black and will not damage the plastic housings.

marianne